

Date: Thursday, 12/15/2005 3:55:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 25251		Part Number	: D32101	
Estimate Number	: 10709		Drawing Number	: D3210 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/15/2005 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/5/2006	
Previous Run	: N/A		Qty:	12	Um: Each
Written By	: SEE COMMENT BELOW		mr. Hiples of 4		
Checked & Approved By	: SEE COMMENT BELOW		12		
Comment	: Est Rev:A New Issue 05-11-17 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet SA 05.12.21
2.0	SHEAR	SHEAR SA 05.12.21
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 JL 06.01.27 12
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE JL 06.01.27 12
5.0	QC8	SECOND CHECK MS 06/01/27 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25251

Part Number: D32101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

DL 06/01/28 12

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/01/28 12

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

MM 06/02/07 12

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CD 06/02/09 12

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 89

CD 06/02/09 12

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/10 12

SP 06/02/10 12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25251
Description: Doubler	Part Number:	D3210-1
Inspection Dwg: D3210	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	MS	Prototype Approval:	N/A
Date:	06-01-27	Date:	06-01-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Removed 14.607 dimension	KJ/JLM	



A circular stamp with the text "QA COPY ISSUED" arranged in a circle.

DESIGN		DRAWN BY	
<i>AN</i>		<i>AN</i>	
CHECKED		APPROVED	
<i>AN</i>		<i>AN</i>	
DRAWING NO.		SHEET 1 OF 1	
D3210		REV. A	
DATE		SCALE	
03.09.03		1:3	
TITLE			
DOUBLER			
A		NEW ISSUE	

D3210-1 DOUBLER

MAKE PER DRAWING FILE "D3210-A1.DWG"

CHECK PER TEMPLATE D3210-1T1

DIMENSIONS SHOWN FOR REFERENCE ONLY

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

WILSON POWDER COAT LINE

POWDER COAT D
DART QSI 005 4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



54 (TYP) DETAIL A
SCALE 2:3

1. *What is the relationship between the two main characters?*

0.312

- R0.312

SEE DETAIL A

SEE DETAIL A

SEE DETAIL A

R0.35 (TYP)

10.30

15.94

11.07

10.10

5.23

5.016

4.28

11.75

11.52

9.65

8.500

4.53

1.095

0.650

0.350

0.000

11.07

11.52

8.500

4.53

1.095

0.650

0.350

0.000

R0.75 (TYP)

φ0.128 (TYP 92 PLACES)

φ0.141 (TYPICAL 8 PLACES SHOWN)

(14 EQUAL SPACES)

20.15

9.259

9.65

10.30

15.94

11.07

10.10

5.23

5.016

4.28

11.75

11.52

8.500

4.53

1.095

0.650

0.350

0.000

14.607

(14 EQUAL SPACES)

3.857

3.500

2.200

0.00

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